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D4634-145
Job Sheet 201704



Part No: D4634-145

Job Qty: 1 pcs

Part Name: Aft, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/9/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 11/15/19

Type: SOLD

Description:

Note: DWG D4634 REV.H SHEET 9 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL VERIFIED BY:JLM IPP Rev C 13/07/09 Dwg Update DL ver: DD IPP Rev D Dwg Update 13/12/23 DL IPP REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	11/15/19		0.00	1.47	Small Fab - 1		DAS 58 NOV 07 2019 Q.P.
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
120	QC 5	1 pcs	11/15/19		0.00	0.00	QC 5 - 10		DAC 40 NOV 14 2019 9-88
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	11/15/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		

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				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	58 NOV 20 2019
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
140 QC 21 - SA	1 pcs	11/15/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	8-89
				QC 21 - SA - 53	NOV 20 2019

Part Op 110 - Small Fab (Small Fab) Assemble as per Dwg D4634-145 Bond foam core to inside of panel 3M Scotch Weld 1300
 Descriptions: Batch: 5214607 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 8154497 Expiry Date 03/27/2020 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: MT5880 11/28/96
 120 - QC5 (QC5- Inspect part completeness to step on W/O) QC5- Inspect part completeness to step on W/O
 130 - Packaging3 (Identify as per dwg & Stock Location: _____) Identify as per dwg & Stock Location: _____
 140 - QC21 (QC21- Final Inspection - Work Order Release)QC21- Final Inspection - Work Order Release

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CCR264SS-3-03	Cherry Rivet	4 Ea (4 ea)	110-Small Fab - 1	S180315
D4634-5	Aft, Center Ceiling Panel	1 pcs (1 ea)	110-Small Fab - 1	S131092
D4636-5	Bracket	1 pcs (1 ea)	110-Small Fab - 1	S129441
D4647-1	Doubler	1 pcs (1 ea)	110-Small Fab - 1	S113182
D4664-5	Spacer	6 pcs (6 ea)	110-Small Fab - 1	S209499
D4712-1	Bracket	1 pcs (1 ea)	110-Small Fab - 1	S232709
D4732-17	Label	1 pcs (1 ea)	110-Small Fab - 1	S020481
D4732-23	Label	1 pcs (1 ea)	110-Small Fab - 1	S101573
D4732-27	Label	1 pcs (1 ea)	110-Small Fab - 1	S224231
D5021-5	Foam, Center Panel, Aft	1 pcs (1 ea)	110-Small Fab - 1	3M 1309231
MPNY-750S-9-C	Mounting Pad	9 pcs (9 ea)	110-Small Fab - 1	S216072
MS20426AD4-6	Rivet	2 Ea (2 ea)	110-Small Fab - 1	S140391
MS21059L08	Nut	2 Ea (2 ea)	110-Small Fab - 1	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	CCR264SS-3-03	4	176	0
	D4634-5	1	2	0
	D4636-5	1	41	0
	D4647-1	1	4	0
	D4664-5	6	7	0
	D4712-1	1	13	0
	D4732-17	1	26	0
	D4732-23	1	12	0
	D4732-27	1	12	0
	D5021-5	1	3	0
	MPNY-750S-9-C	9	104	0
	MS20426AD4-6	2	873	0
	MS21059L08	2	139	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

DISPOSITION		DEPARTMENT/PROCESS					
Job: _____	Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐		
Part No. _____	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐		
	Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐		
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042) ☐			
Description Work Order Deviation		Disposition					
		Completed By					
		Lead hand / Supervisor					
		QC / QA Coordinator					
Root Cause		FAULT CATEGORY					
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐			
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐			
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐			
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐			
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐				
Human Factors ☐	Other/Details: _____						